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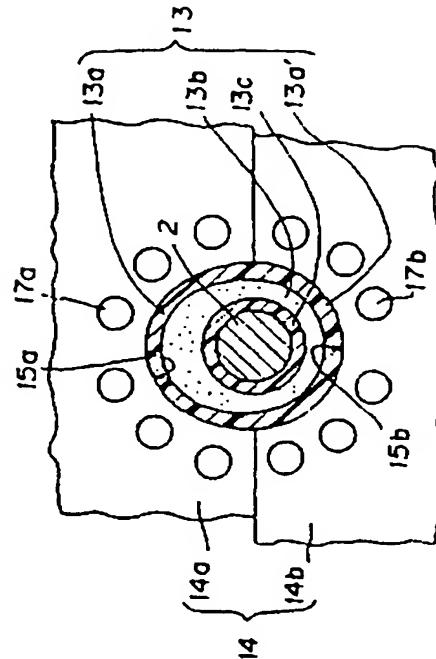
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TITLE : MOLDING METHOD FOR REACTION
 INJECTION MATERIAL



ABSTRACT : PURPOSE: To mold a steering wheel which is thick where human hands all the time touch and thin at the back by setting the molding temperature corresponding to a thick skin layer lower than the molding temperature corresponding to a thin layer and reaction injection molding.

CONSTITUTION: A mold 14 consists of a top force 14a and a bottom force 14b, and the back face side of a steering wheel is disposed in the top force 14a, while heat medium passages 17a and 17b are formed in a mold close to cavity faces 15a and 15b of circular ring-shape in sections. The heat medium temperature of heat medium temperature controller is set separately for the top and bottom forces, and the temperature of a bottom force cavity face 15b corresponding to the front side of the steering wheel is set higher than that of a top force cavity face 15a corresponding to the back side of the steering wheel. The front side of a coated layer 13 of the steering wheel has a thick and hard skin layer 13a, while the back face side makes a thin skin layer 13a to prepare a soft molded product.

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